

NS1

Revision ID:

NS2

Item Name: Step Weldment

Start Date: 5/16/2017 **Start Qty:** 4.00

~~*4*~~
~~*4*~~ 3

Cust Item ID:

Required Date: 6/2/2017 **Req'd Qty:** 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

[illegible]

Work Order ID 157772

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157772

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Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment
Start Date: 5/16/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/2/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							DAS 24 9-89
130									
QC	Memo	0.04							
Quality Control									

140	Small Fab	0.00							DAS 24 9-89
140									
Small Fab	Memo	2.95							
Small Fab	1- Transfer drill Rivet holes as per dwg D3562.								

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Scotch-Weld as per dwg D3562.

*****Ensure to wipe off any excess magnobond *****

A/R Scotch-Weld DP460

Batch: 136223

EXP DATE: 11/17

3x O.M.L. 2017-06-07

240
45
38

240
45
38

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Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment
 Start Date: 5/16/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/2/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180						3			JUN 21 2017
QC	Memo	0.08							
Quality Control									
190	Chemical Conversion Coat per QSI005 4.1	0.00							
190						(X3)			2017/06/22
HandFinish	Memo	0.69							BEB
Hand Finishing									
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200						3			17-06-23
Powdercoat	Memo	1.26							
Powder Coating	START TIME: 10:00 OVEN TEMPERATURE: 325° FINISH TIME: 10:30								

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Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment
 Start Date: 5/16/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/2/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Wing Walk as per dwg QSI005 4.4 Batch <u>M137465</u>	0.00							
210	HandFinish	1.51				(x3)	✓		20170706 BER
Hand Finishing	Memo								
220	QC3- Inspect Part Finish	0.00							
220	QC	0.04				3			DAS 36 9-88 JUL 07 2017
Quality Control	Memo								
230	Identify as per dwg & Stock Location: <u>u/b</u>	0.00							
230	Packaging	0.04				3x			DAS 36 9-88 17/07/11
Packaging	Memo <u>160798</u>								

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Item ID: D3562-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Weldment

Start Date: 5/16/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/2/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.40

Quality Control

17/7/13



JUL 11 2017

Picklist Print

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Work Order ID: 157772

157772

Parent Item: D3562-042

D3562-042

Parent Item Name: Step Weldment

Start Date: 5/16/2017

Required Date: 6/2/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E
 13.06.03 PER DWG REV.F DD VERF:JLM IPP REV:F 16.06.23
 AS PER DWG REV.G DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C		Manufactured	No			100	Each	121.5000	1	4			
D2622-120C									**			<u>2017-05-18</u>	
Step Extrusion													

Location	Loc Qty	Loc Code
WA003	121.5	B157411 → 4x
152316	18.5	
157441	103	

D2734		Manufactured	No			140	Each	39.0000	2	8			
D2734									**				
Step End Plate													

Location	Loc Qty	Loc Code
WA003	39	B161519
156811	19	
159746	20	

D3560-042		Manufactured	No			140	Each	4.0000	1	4			
D3560-042									**			<u>DML 2017-06-7</u>	
Arm Weldment													

Location	Loc Qty	Loc Code
WA003	4	B160582 → 3
160582	4	

Picklist Print

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Work Order ID: 157772

157772

Parent Item: D3562-042

D3562-042

Parent Item Name: Step Weldment

Start Date: 5/16/2017

Required Date: 6/2/2017

Start Qty: 4.00

Required Qty: 4.00

D3560-044

Manufactured

No

140

Each

5.0000

1

4

D3560-044

Arm Weldment

**

D.M.L 2017-06-09

Location

Loc Qty

Loc Code

WA003

5

1

4

151524

160805

B160805 → 3

MS20600-AD4W4

Purchased

No

140

Each

1,522.000

32

128

MS20600-AD4W4

Rivet

**

D.M.L 2017-06-09

Location

Loc Qty

Loc Code

CCK004

1011

11

1000

M135704

M137412

ST308

46

46

M137075

WA003

465

M135442

204

M136986

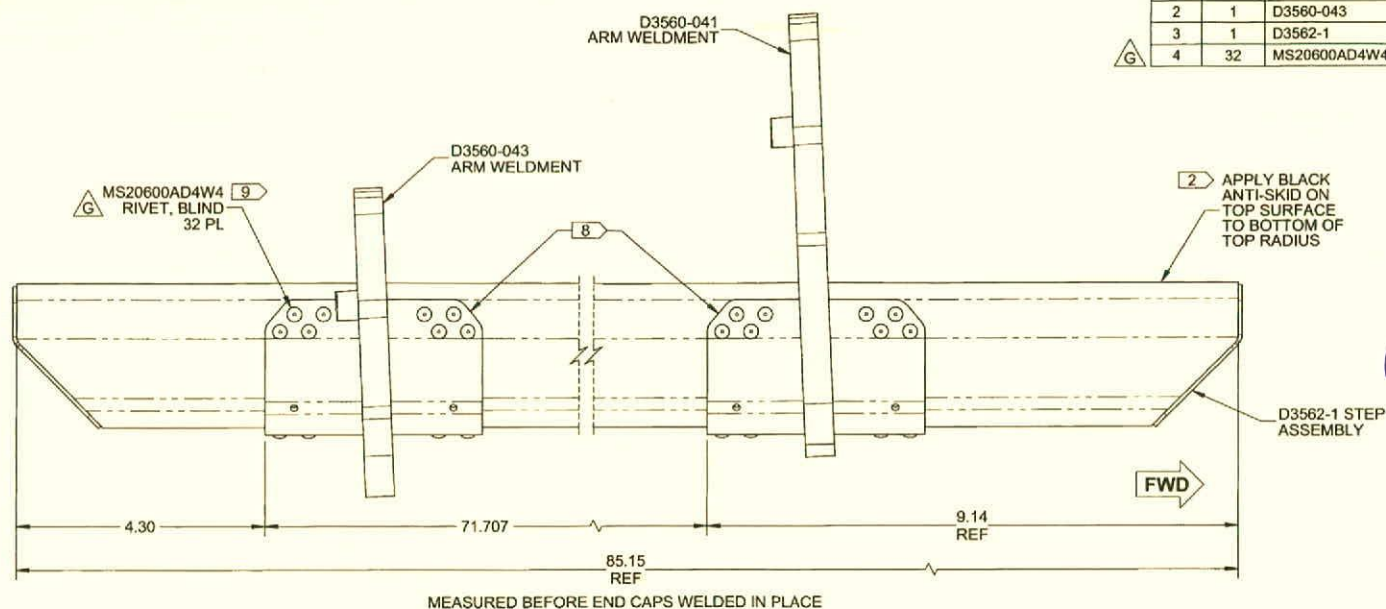
108

M137075

153

B137412 → 96

ITEM	QTY	P/N	DESCRIPTION
	X	D3562-041	LH STEP ASSEMBLY
1	1	D3560-041	ARM WELDMENT
2	1	D3560-043	ARM WELDMENT
3	1	D3562-1	STEP ASSEMBLY
4	32	MS20600AD4W4	RIVET, BLIND



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY:
 - GLOSS WHITE (4.3.5.1) OR
 - GREY SANDTEX (4.3.5.6) OR
 - BLACK SANDTEX (4.3.5.7) OR
 - GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.80 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING



D3562-041 LH STEP ASSEMBLY

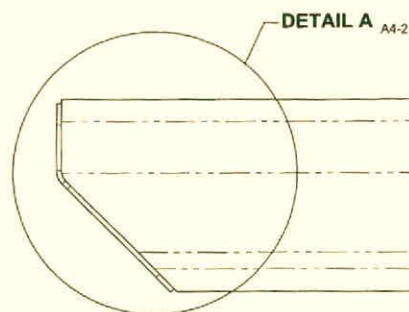
G	MS20600AD4W4 WAS MS20600AD4W5. REF. PAR16-517.	MB	16.04.21
F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PAR12-224. ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE: REDRAW IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. G
MFG. APPR.	DD	D3562	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
DATE	16.04.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

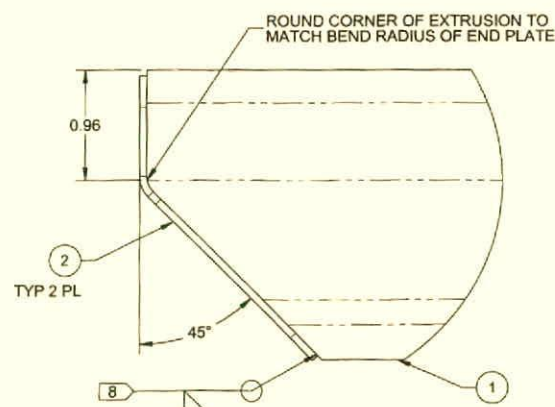
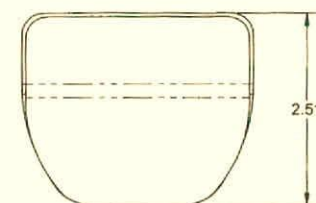
RELEASED

2016 JUN 22 97
FCN 16-661

ITEM	QTY	P/N	DESCRIPTION
	X	D3562-1	STEP ASSEMBLY
1	A/R	D2622-XXX	STEP EXTRUSION
2	2	D2734	END PLATE



D3562-1 STEP ASSEMBLY



DETAIL A D6-2
TYP BOTH ENDS
SCALE 1.5X

RELEASED

2016 JUN 22 *q*

NOTES:

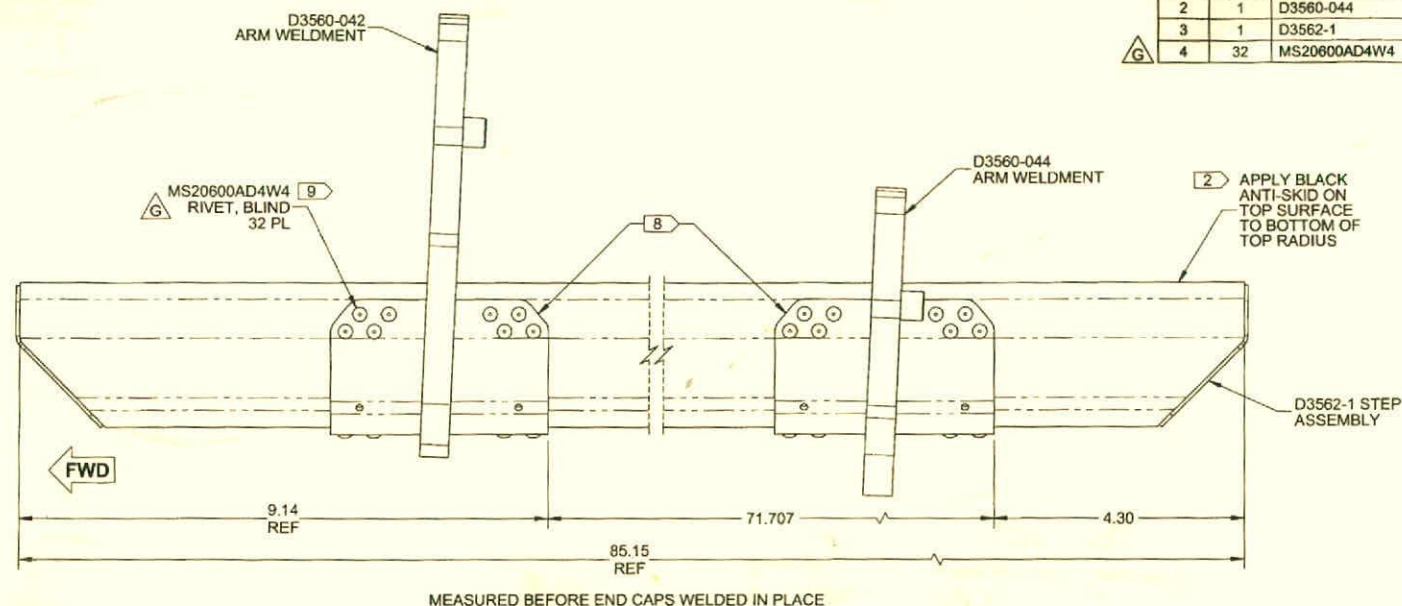
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.68 lbs
- 8) WELDING: ALL WELDS SHALL BE 100% VISUALLY INSPECTED
BY A QUALIFIED INSPECTOR PER DART QSI 004

APPROVED

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO	REV. G
MFG. APPR.	DD	D3562	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
DATE	16.04.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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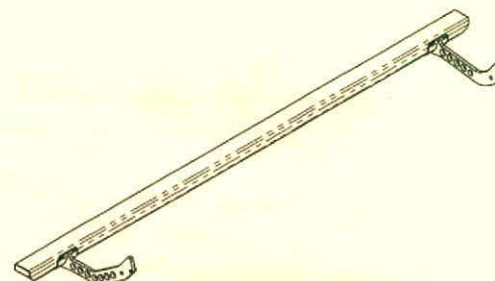
8 7 6 5 4 3 2 1

ITEM	QTY -042	P/N	DESCRIPTION
	X	D3562-042	RH STEP WELDMENT
1	1	D3560-042	ARM WELDMENT
2	1	D3560-044	ARM WELDMENT
3	1	D3562-1	STEP ASSEMBLY
4	32	MS20600AD4W4	RIVET, BLIND



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY:
 - GLOSS WHITE (4.3.5.1) OR
 - GREY SANDTEX (4.3.5.6) OR
 - BLACK SANDTEX (4.3.5.7) OR
 - GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.80 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING



D3562-042 RH STEP ASSEMBLY

RELEASED

2016 JUN 22 4

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D3562	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

